

Date: Friday, 23/01/2009 2:58:15 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MONOPOD ASS'Y
 Job Number : 45217
 Estimate Number : 13177
 P.O. Number : Part Number : D3686041
 This Issue : 23/01/2009 S.O. No. : Drawing Number : D3686 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 44526 Material :
 Written By : Due Date : 28/01/2009 Qty: 1 Um: Each
 Checked & Approved By : MF 09-01-23
 Comment : Est Rev:A new issue 08-02-12 DD verified by:JLM
 Est Rev:B As per Rev B 09-01-07 JLM Verified By:EC
 Est Rev:C Added sealant note as per Rev C 09-01-20 JLM
 Verified By:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

2.0 D36887 STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STUD

batch B 44686MF 09-01-28

3.0 D36891 SLEEVE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SLEEVE

batch 44687MF 09-01-28

4.0 D36911 STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STUD

batch 44688MF 09-01-28

5.0 D36921 SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch 44689MF 09-01-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MONOPOD ASS'Y

Job Number: 45217

Part Number: D3686041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D36923

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch 44728

MF 09-01-27

7.0

D36931

Rod End Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod End Bearing

batch 44691

MF 09-01-27

8.0

D36933

Rod End Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod End Bearing

batch 36880

MF 09-01-27

9.0

AN3C10A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

1105940

MF 09-01-27

10.0

AN3C12A

Bolts



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolts

batch 106993

MF 09-01-27

11.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch 110023

MF 09-01-27

12.0

NAS509L12C

Nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nuts

batch 1106993

MF 09-01-27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/01/2009 2:58:15 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MONOPOD ASS'Y

Job Number: 45217

Part Number: D3686041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

NAS50912C

Nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nuts

batch 106243

mk 09-01-27

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3686

2-Assemble D3693-1 & D3691-1 & D3693-3 & D3688-7 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3686

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3686

090128

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

090128 (X1)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

#44424

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

090129

Job Completion



mk 09-01-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

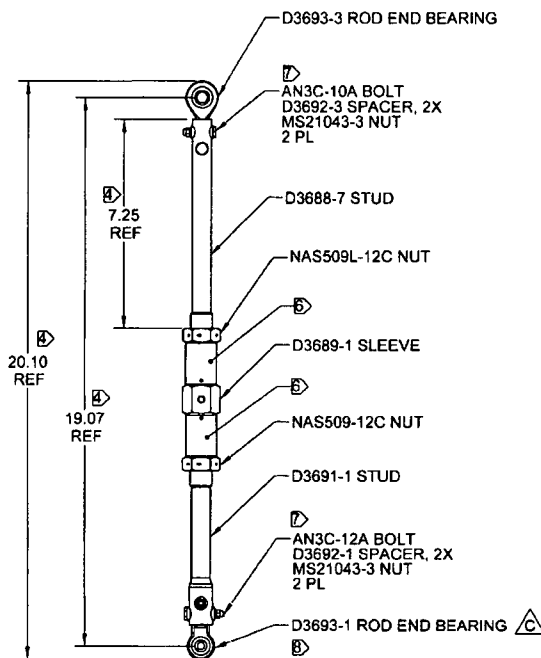
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONOPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	AN3C-12A	BOLT
11	4	MS21043-3	NUT
12	1	NAS509L-12C	NUT
13	1	NAS509-12C	NUT



D3686-041 MONOPOD ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

RELEASED
09/01/12

C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN A8-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.12.15		

DART AEROSPACE LTD
HAWKESSBURY, ONTARIO, CANADA

DRAWING NO.
D3686

REV. C
SHEET 1 OF 1

TITLE
MONOPOD ASSEMBLY

SCALE
NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

